

Work Order ID 153256

Tuesday, November 15, 2016 11:17:41 AM

153256

PRELIMINARY ISSUE

Page 1

Item ID: 647.7341

Revision ID:

Item Name: Wiper Deflector Assembly

Start Date: 12/1/2016 Start Qty: 1.00

Required Date: 12/1/2016 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: VS

Date: 12/14/16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100	Document Control	0.00							
100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP 647.7341								
110	Pick Kit	0.00							
110	Packaging	0.00							
Packaging	Memo								
120	QC4- 100% Inspect kits for completeness	0.00							
120	QC	0.00							
Quality Control	Memo								

POSITIVE
RECALL

1
1

Accept

N900040100

Setup

Start

NS1

Stop

NS2

Cust Item ID:

Customer:

100

100

DC

Doc.Control -USB or Paperwork

110

110

Packaging

Packaging

120

120

QC

Quality Control

Document Control
DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP 647.7341

Pick Kit

Memo

QC4- 100% Inspect kits for completeness

Memo

DEC 15 2016

0.00

0.00

0.00

0.00

0.00

DAS
27
9-89

DEC 19 2016

NOV 17 2016
68-6
9
DAS

DAS
27
9-89

DEC 19 2016

SHIP DEC 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 153256

Tuesday, November 15, 2016 11:17:41 AM

153256

Page 2

Item ID: 647.7341

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wiper Deflector Assembly

Start Date: 12/1/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/1/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP 647.7341 Location : FG109								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89DAS
21
9-89

DEC 19 2016

DEC 19 2016

DEC 19 2016



POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

RD161006-01

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Tuesday, November 15, 2016 11:17:40 AM

Page 1

Work Order ID: 153256

153256

Parent Item: 647.7341

647 7341

Parent Item Name: Wiper Deflector Assembly

Start Date: 12/1/2016

Required Date: 12/1/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.09.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.1601 *647 1601* Wiper Deflector Aft		Manufactured	No				Each	3.0000	**	1		DAS 6 9-89 NOV 17 2016	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				CCK091			3						
					148295		1						
					151482		2						
647.1610 *647 1610* Wiper Deflector Fwd		Manufactured	No				Each	17.0000	**	1		DAS 6 9-89 NOV 17 2016	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				CCK091			17						
					125082		13						
					M130388		4						
647.1914 *647 1914* Bracket		Manufactured	No				Each	5.0000	**	1		DAS 6 9-89 NOV 17 2016	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				CCK110			5						
					109733		5						
647.1602 *647 1602* Doubler Assembly		Manufactured	No				Each	24.0000	**	1		DAS 6 9-89 NOV 17 2016	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				CCK107			24						
					92479		3						
					MT30388		21						

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Tuesday, November 15, 2016 11:17:40 AM

Page 2

Work Order ID: 153256

153256

Parent Item: 647.7341

647 7341

Parent Item Name: Wiper Deflector Assembly

Start Date: 12/1/2016

Required Date: 12/1/2016

Start Qty: 1.00

Required Qty: 1.00

647.3201 Manufactured No

Each 4.0000 1

647.3201

Grounding Cable Assembly

**

NOV 17 2016
DAS 6
9-89

Location

Loc Qty

Loc Code

cck111

4

123417

4

AN4CH6A Purchased No

Each 40.0000

AN4CH6A

Bolt

**

NOV 17 2016

Location

Loc Qty

Loc Code

ST345

40

123525

20

m126176

20

MS21042-08 MS21042L08 Purchased No

Each 0.0000

MS21042-08

USE MS21042L08

**

NOV 17 2016

MS21042-3 MS21042L3 Purchased No

Each 0.0000

MS21042-3

Nut

**

NOV 17 2016

MS27039-08-07 Purchased No

Each 100.0000

MS27039-08-07

SCREW

**

NOV 17 2016

Location

Loc Qty

Loc Code

ST278

100

m132035

100

DAS 27
9-89

1

NOV 17 2016

DAS 6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, November 15, 2016 11:17:40 AM

Page 3

Work Order ID: 153256

153256

Parent Item: 647.7341

647 7341

Parent Item Name: Wiper Deflector Assembly

Start Date: 12/1/2016

Required Date: 12/1/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-07

Purchased

No

Each

182.0000

3

MS27039-1-07

Screw

NOV 17 2016

Location

Loc Qty

Loc Code

GA

2

125654

2

ST281

180

m135948

180

Each

706.0000

4

MS27039-1-14

Purchased

No

MS27039-1-14

Screw

NOV 17 2016

Location

Loc Qty

Loc Code

GA

94

120449

94

over006

500

124326

500

ST280

112

124326

112

Each

60.0000

3

601.2999

Manufactured

No

601 2999

Screw

NOV 17 2016

Location

Loc Qty

Loc Code

CCK098

60

91707

10

93369

50

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				OTHER : _____			

Picklist Print

Page 4

Tuesday, November 15, 2016 11:17:40 AM

Work Order ID: 153256

153256

Parent Item: 647.7341

647 7341

Parent Item Name: Wiper Deflector Assembly

Start Date: 12/1/2016

Required Date: 12/1/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

Each

1,463.000

2

NAS1149FN832P

Washer

NOV 17 2016
DAS
6
9-89

Location

Loc Qty

Loc Code

GA

1285

M135058

1285

ST263

178

M135603

178

Each

2,610.000

10

NOV 17 2016

NAS1149F0332P

Purchased

No

NAS1149F0332P

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

343

m133709

343

ST262

2267

m135544

267

m135948

2000

Each

62.0000

3

NOV 17 2016
DAS
6
9-89

601.2375

Manufactured

No

601 2375

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

CCK096

62

91708

62

Tuesday, November 15, 2016 11:17:40 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 15: Universal Wiper Deflector (WD) Assembly, 647.7341

FIND #	PART #	DESCRIPTION	QTY
4	647.1601	WIPER DEFLECTOR ASSY, AFT	1
5	647.1610	WIPER DEFLECTOR, FWD	1
29	647.1914	BRACKET	1
30	647.1602	DOUBLER ASSY	1
35	647.3201	GROUNDING CABLE ASSY	1
47	601.1324	BOLT	1
52	601.2973	LOCKNUT	1
53	601.2943	LOCKNUT	3
60	601.2525	SCREW	1
63	601.2198	SCREW	3
67	601.1622	SCREW	4
72	601.2999	SCREW	3
85	601.2764	WASHER	2
86	601.1607	WASHER	10
89	601.2375	WASHER	3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153296
[Signature]

DEC 15 2016

Work Order ID 153256

Friday, December 16, 2016 10:23:03 AM

153256

Page 1

Item ID: 647.7341

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: EC135 Universal Wiper Deflector Assembly

Start Date: 12/1/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/1/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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MPP-195

N/C

100	Document Control	0.00
100	DOCUMENT CONTROL	
DC	Memo	0.00
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP 647.7341	

DAS
21
9-89

DEC-16-2016

110	Pick Kit	0.00
-----	----------	------

110

Packaging	Memo	0.00
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Packaging

120	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

120

QC	Memo	0.00
----	------	------

Quality Control

Marie Lajeunesse

From: Kim Johnston
Sent: Friday, December 16, 2016 9:51 AM
To: Marie Lajeunesse
Subject: FW: EC135 CCK MPP & IIN corrections

Thanks,

Kim Johnston
*Engineering Clerk
Document Administrator*

DART AEROSPACE
T 1 613 632-5200 > ext. 226
F 1 613 632-9311



From: Sian Willems
Sent: Monday, December 12, 2016 9:21 AM
To: Lisa McMachen <lmcmachen@dartaero.com>; Kim Johnston <kjohnston@dartaero.com>
Subject: RE: EC135 CCK MPP & IIN corrections

Go ahead and load. A corrected version will follow once DaveM makes the updates.

SIAN WILLEMS
Customer Support Manager

DART AEROSPACE
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From: Lisa McMachen
Sent: Monday, December 12, 2016 8:26 AM
To: Kim Johnston <kjohnston@dartaero.com>; Sian Willems <swillems@dartaero.com>
Subject: FW: EC135 CCK MPP & IIN corrections

Hi Sian,
Kim says that the paperwork is not jiving...can we load the attached documents to the website as discussed on Friday? Please see the attached email.

Thanks,
Lisa McMachen

From: Sian Willems
Sent: Monday, December 12, 2016 7:21 AM

REFERENCE ONLY



SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 15: Universal Wiper Deflector (WD) Assembly, 647.7341

FIND #	PART #	DESCRIPTION	QTY
4	647.1601	WIPER DEFLECTOR ASSY, AFT	1
5	647.1610	WIPER DEFLECTOR, FWD	1
29	647.1914	BRACKET	1
30	647.1602	DOUBLER ASSY	1
35	647.3201	GROUNDING CABLE ASSY	1
47	601.1324	BOLT A74CH6A	1
52	601.2973	LOCKNUT MS21042-G8	1
53	601.2943	LOCKNUT MS21042-3	3
60	601.2525	SCREW MS27039-0807	1
63	601.2198	SCREW MS27039-1-07	3
67	601.1622	SCREW MS27039-1-14	4
72	601.2999	SCREW	3
85	601.2764	WASHER NAS1149F0830P	2
86	601.1607	WASHER NAS1149F0330P	10
89	601.2375	WASHER NAS1149F0330P	3